

Work Order ID 147531-2

Thursday, June 09, 2016 8:49:42 AM

Split x3

147531

Aug 18 x1
~~Aug 26 x3~~
 Aug 26 x3

Page 1

Item ID: D350-591-121

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016 Start Qty: 2.00

2 4 SH 3
 2 4 3

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: JUN 13 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2351-041	Rev E
-----------	-------

IIN-D350-591	H
--------------	---

AUG 19 2016

DAS
6
9-89

DAS
21
9-89

1608-19 3

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

X3 DAS
27
9-89

AUG 22 2016

110

Large Fab

0.00

110

Large Fab

Memo

0.13

Large Fab

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

4 1608-02 BE

B#147531 x3 LH

135

Am. J. 31.4

135

Work Order ID 147531

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147531

Page 2

Item ID: D350-591-121

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	BENDING MACHINE - SKIDTUBES	0.05							
120									
CNC Bend 1	Memo	0.04							
CNC Delta 100 Bender	Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.								

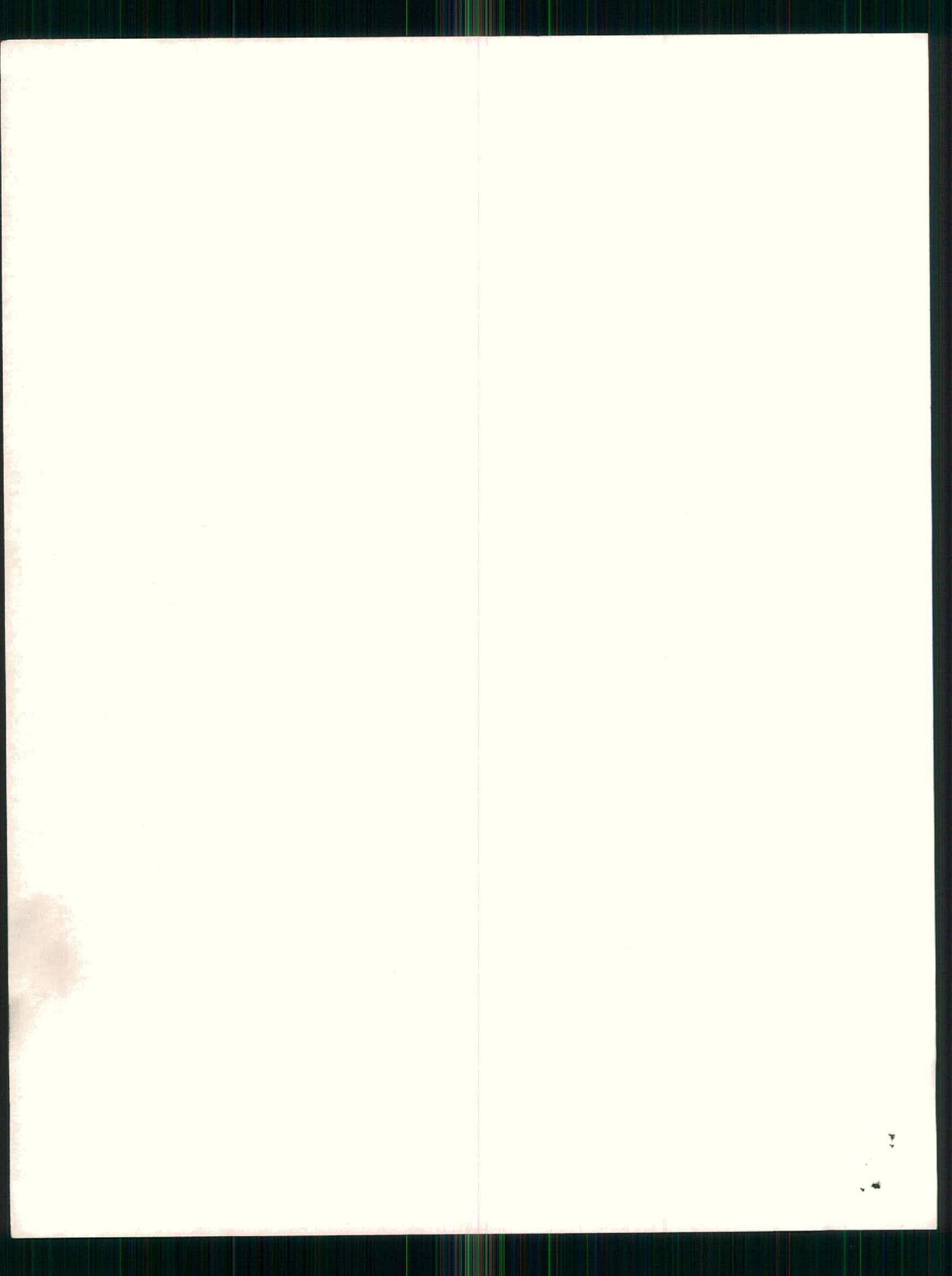
122	QC5- Inspect part completeness to step on W/O	0.00							
122									
QC	Memo	0.01							
Quality Control									

126		0.00							
126									
Large Fab	Memo	0.00							
Large Fab	***BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer***								

DAS
18
9-89TW 16-08-09
JL

4 0 16-08-04

4 0 BE 16-08-04



Work Order ID 147531

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Page 3

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible
Start Date: 5/27/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/8/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

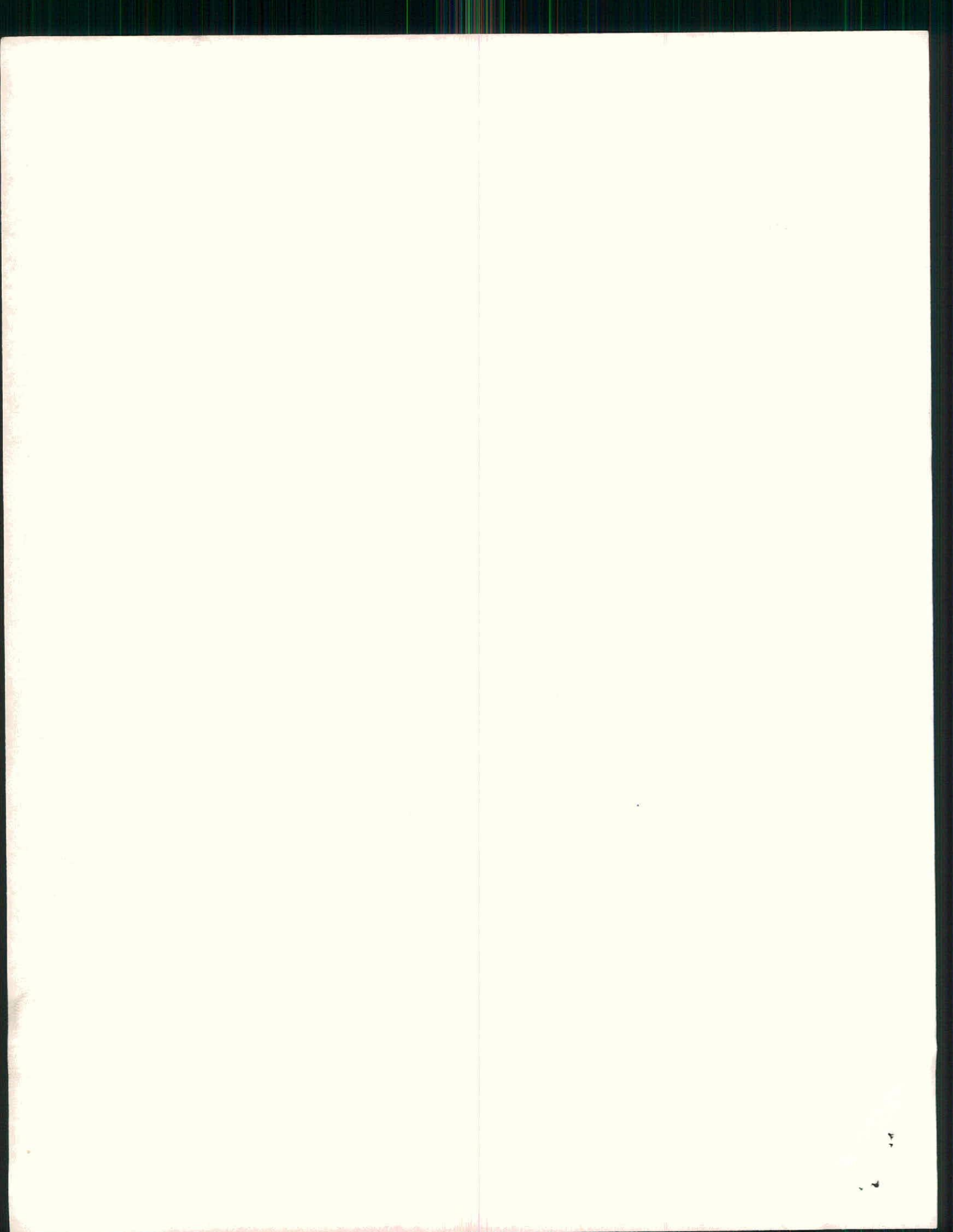
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.01							
Quality Control									
140		0.00							
140	Large Fab								
Large Fab	Memo	0.11							
Large Fab	1-Bevel Fwd and Aft end for welding								
	2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033								
	A/RAluminum Rod M131562 MB4826								
	3-Do not Grind Flush								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									

(4) 16-08-06 AD

BE16-08-10

(7) 16-03-15 AD



Work Order ID 147531

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Page 4

Item ID: D350-591-121 Accept

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016 Start Qty: 2.00 *2*

Required Date: 6/8/2016 Req'd Qty: 2.00 *2*

Reference:

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

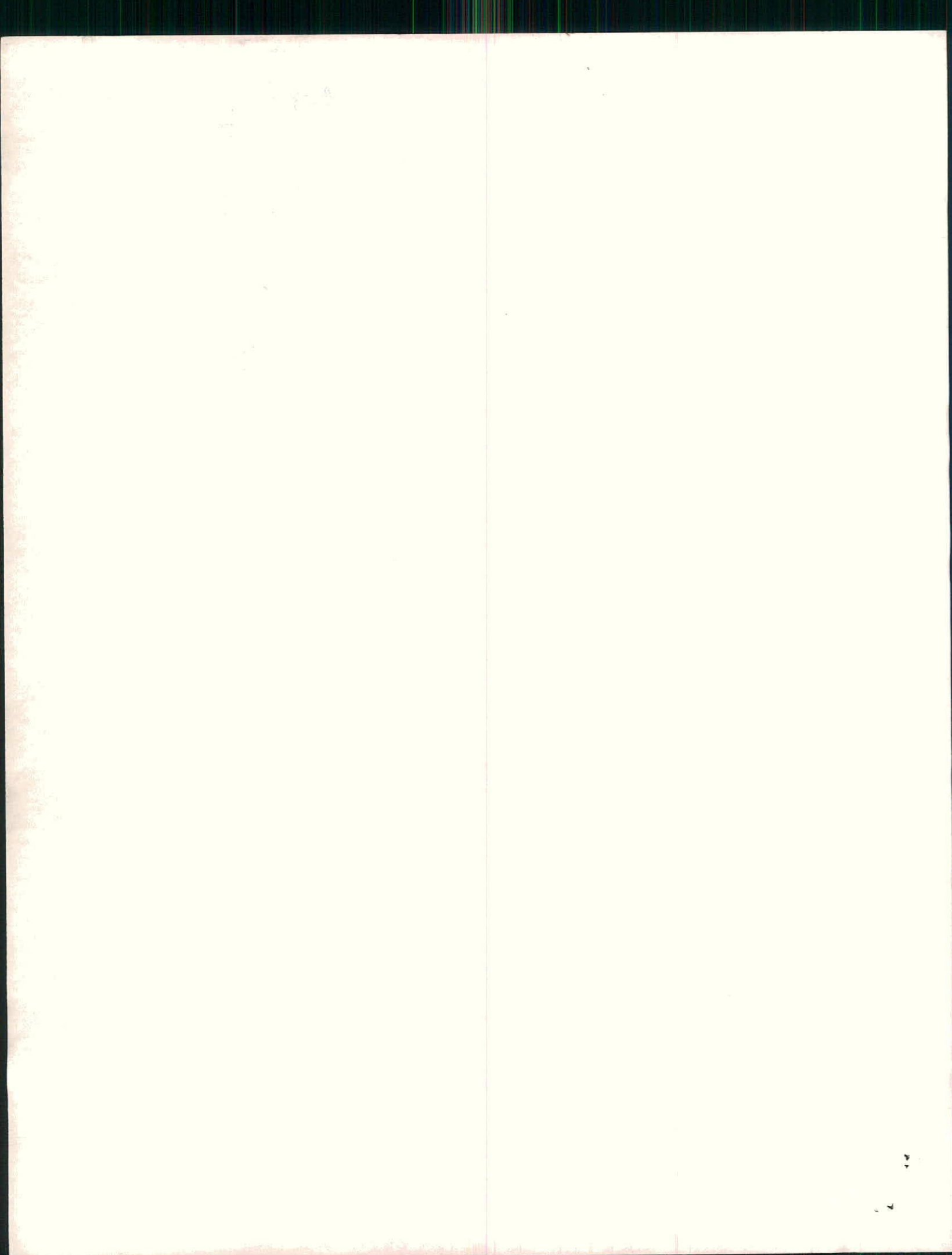
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.01							
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.06							
Hand Finishing									
180	QC7-Inspect Chemical Conversion Coat	0.00							
180									
QC	Memo	0.00							
Quality Control									

(4) 16-08-15 PD

(4) 16-8-15 JH

DAS
18
9-89

4 16-08-15



Work Order ID 147531

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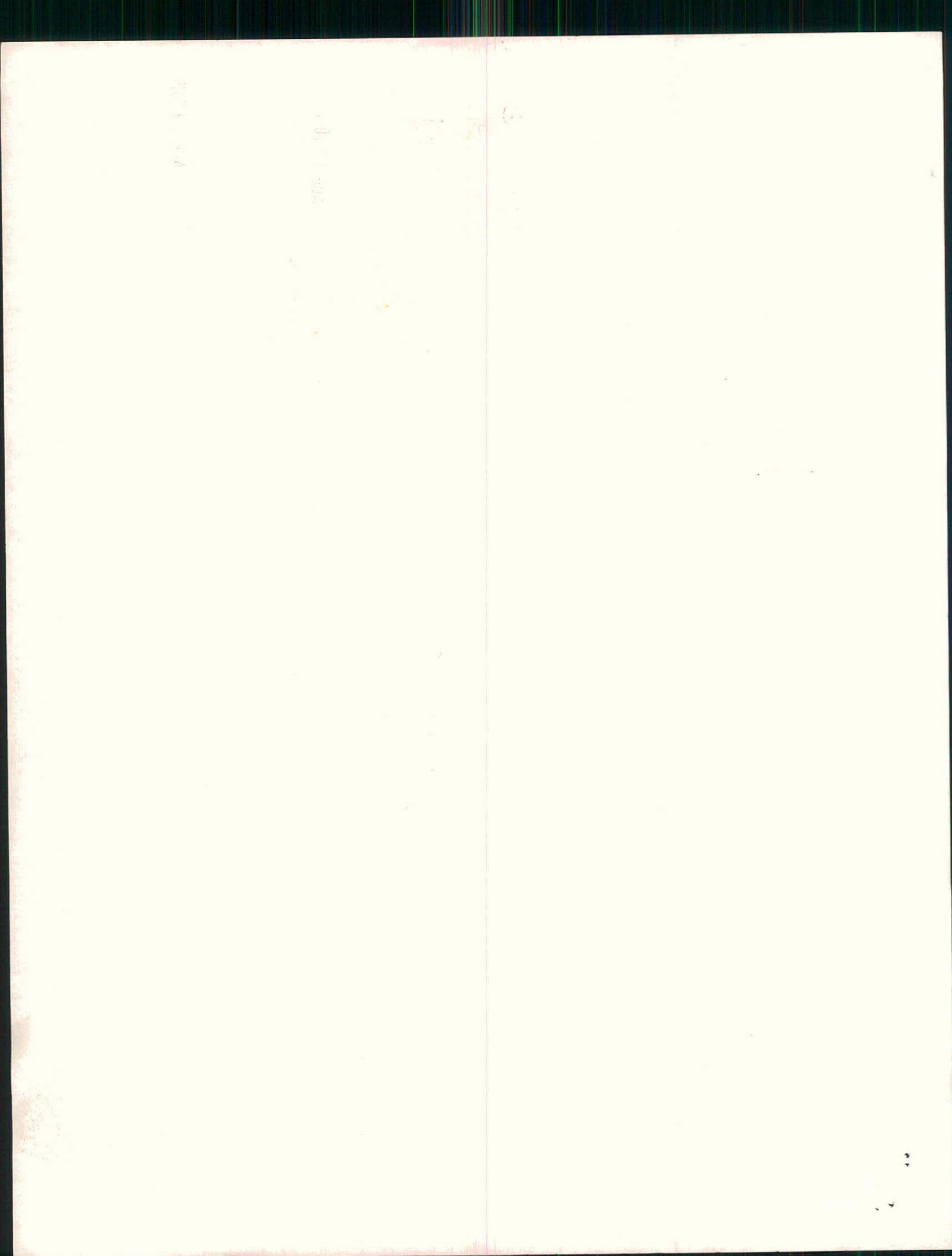
147531

Page 5

Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible
 Start Date: 5/27/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/8/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Large Fab	Large Fab	0.00				<u>3</u>	<u>0</u>	<u>BE160816</u>	
	Memo	0.11							
	1-Rivet Leg Assembly as per Dwg D2351								
	2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod <u>M131562/M134826</u>								
	3-Grind end cap flush per dwg D2351								
220 *220* QC	QC10- Inspect visual per QSI004- ground welds	0.00				<u>3</u>			DAS 38 9-89 AUG 17 2016
	Memo	0.00							
230 *230* QC	QC5- Inspect part completeness to step on W/O	0.00				<u>3</u>			DAS 38 9-89 AUG 17 2016
	Memo	0.01							
	Quality Control								



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Accept

Setup Start *NS1*

Stop ***NS2***

Stop ***NS2***

Cust Item ID:

Customer:

Run Start *NR1*

Stop ***NR2***

Stop ***NR2***

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

(3) _____ 2016/08/17
BFD

3 ϕ . 16-08-17. DAS 34 9-89

START TIME: 2:30
OVEN TEMPERATURE: 350°
FINISH TIME: 3:00

3xLH 2016/08/18
DAS
12
9-89 EB

Handwritten text, possibly a signature or date, in the top left corner.

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Page 7

Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Stop *NR2*

[illegible]

AUG 22 2016

100, 100, 100

Work Order ID 147531

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Page 8

Item ID: D350-591-121 Accept

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016 Start Qty: 2.00 *2*

Required Date: 6/8/2016 Req'd Qty: 2.00 *2*

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

N900040100Setup Start ***NS1***Stop ***NS2***

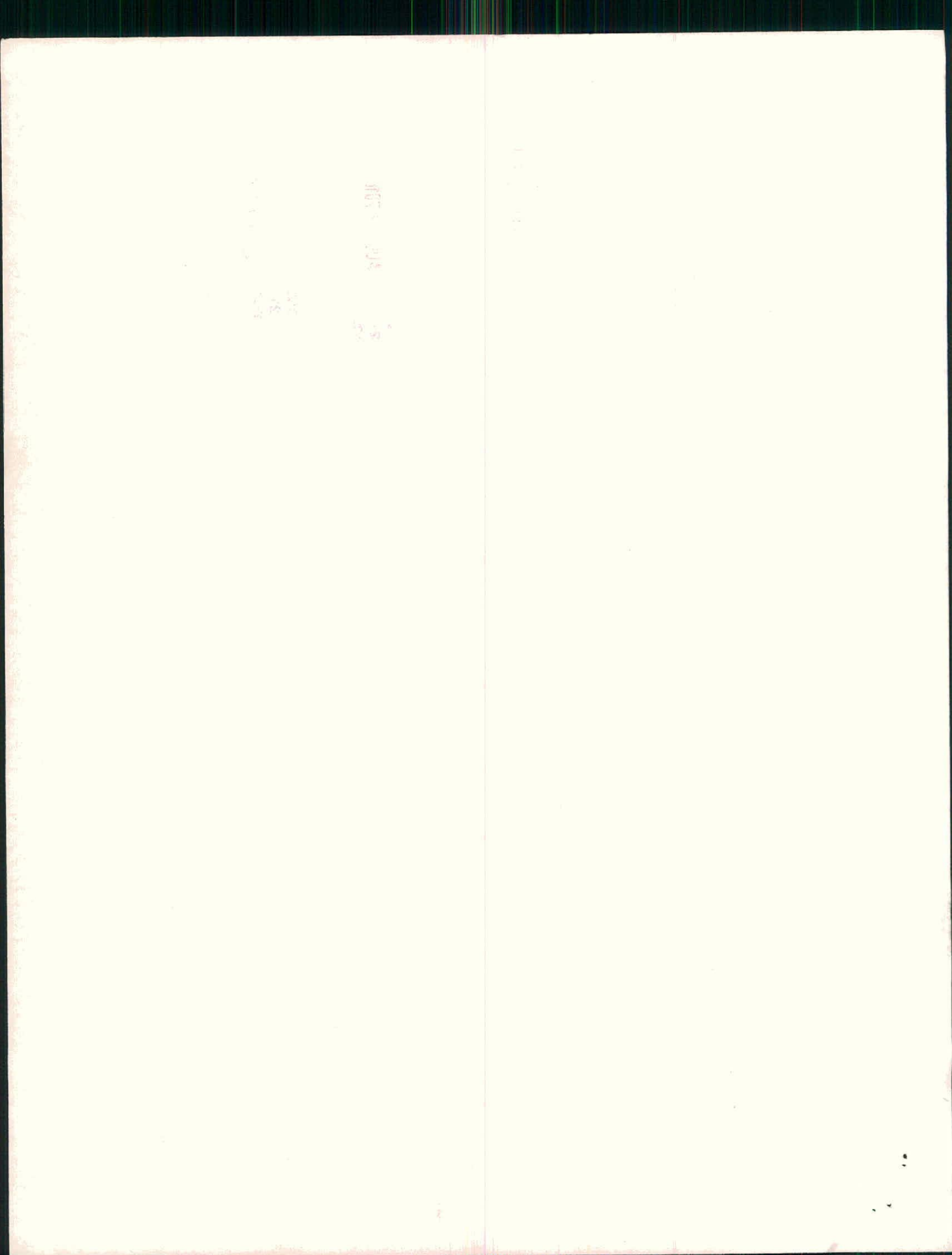
Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-121 Location:FG039								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.03							
Quality Control									

3x **DAS**
28
9-89 **AUG 2 2 2016****DAS**
21
9-89 **AUG 2 3 2016****DAS**
21
9-89 **AUG 2 3 2016**



Picklist Print

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Page 1

Work Order ID: 147531

147531

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016

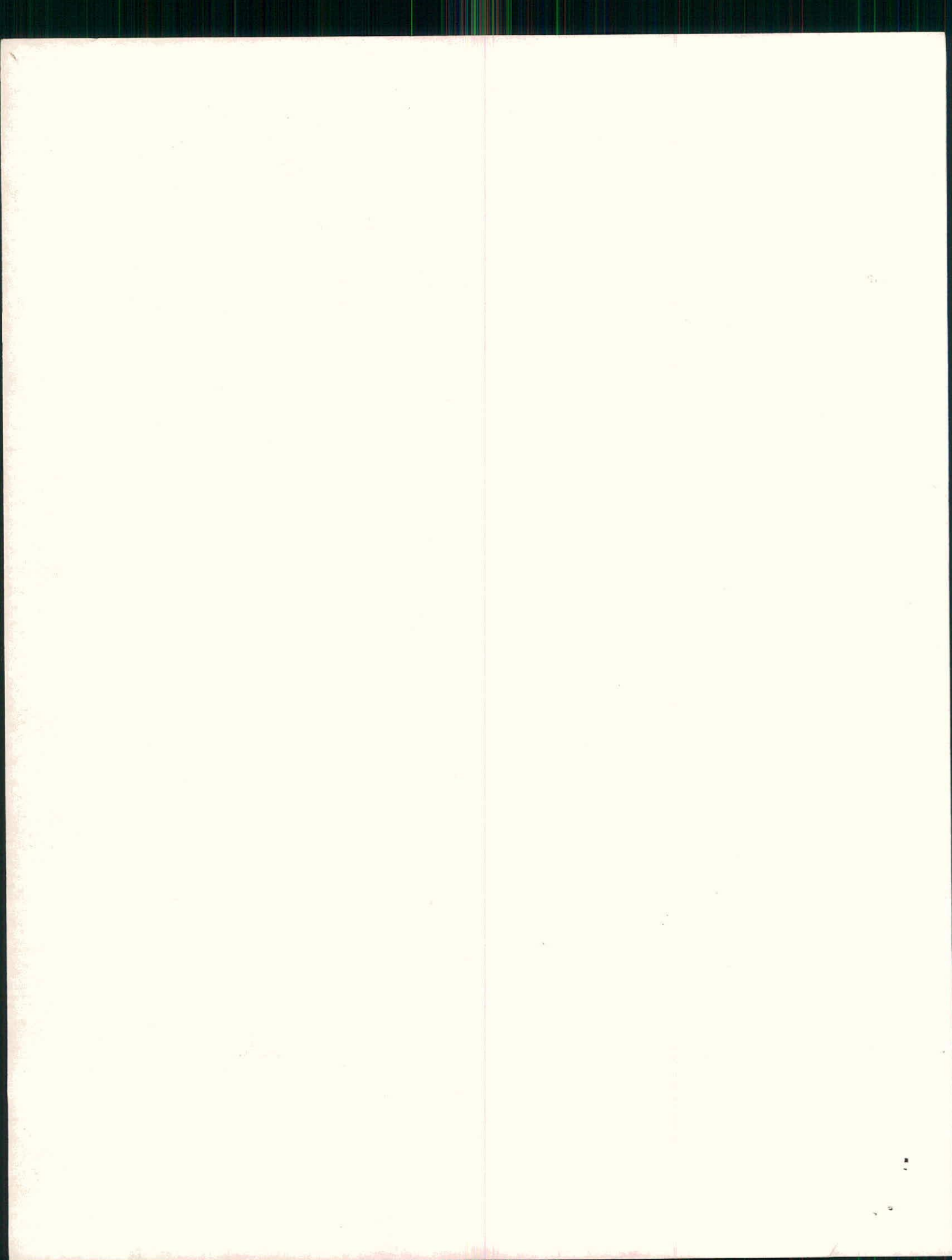
Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116		Manufactured	No			110	Each	62.0000	0.5	2			
D2244-116									**			BE16-08-02	
STEP EXTRUSION													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		62							
				117818		62							
				WA003		-0.0000368							
D2850-1		Manufactured	No			140	Each	12.0000	1	2			
D2850-1									**			BE16-08-02	
End Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		12							
				144767		12							
D2582		Manufactured	No			190	Each	1.0000	1	2			
D2582									**			BE1608-15	
Hi-Skid Step Leg Ass'Y												3148887x4	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		1							
				138942		1							



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Page 2

Work Order ID: 147531

147531

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

MS20600-AD4W3

Purchased

No

190

Each

330.0000

16

32 48

MS20600-AD4W3

Cherry Rivets

**

BE160816

B135297464

Location

Loc Qty

Loc Code

GA

160

m129795

160

ST308

86

m134167

86

WA003

84

m130018

84

D2673-34

Manufactured

No

210

Each

14.0000

1

2

D2673-34

End Plate

**

BE16-08-00

Location

Loc Qty

Loc Code

WA003

14

139627

14

AN4-16A

Purchased

No

290

Each

93.0000

2

AN4-16A

Bolt

**

2+2

+6

X m 135127

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

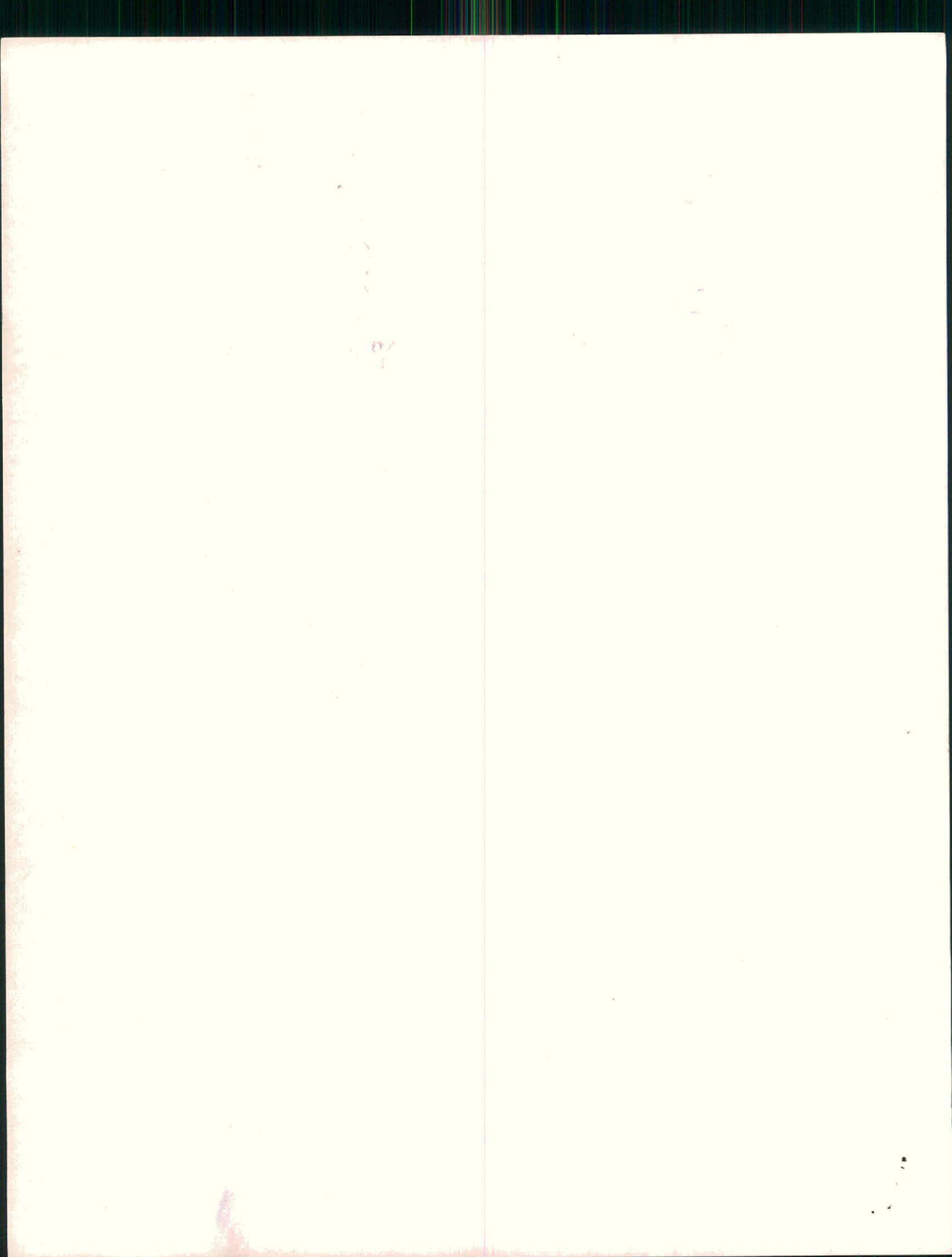
ST343

88

M134762

88

AUG 19 2016



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Page 3

Work Order ID: 147531

147531

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

290

Each

3,657.000

6

NAS1149D0463.I

WASHER

**

1812
X m IBS 390 R ^{DAS} 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

86

M132035

21

M134508

65

ST260a

2000

M134852

1000

M134943

1000

ST263

1571

M134754

1571

D2230-1

Manufactured

No

290

Each

84.0000

1

D2230-1

Mounting Lug

**

83
X B 146288 R ^{DAS} 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

84136

4

ST521

30

115306

1

140536

29

ST525A

50

145246

50

AN3-37A

Purchased

No

290

Each

61.0000

2

AN3-37A

Bolt

**

46
X m IBS 135 R ^{DAS} 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

119086

10

ST347

51

m133694

1

m134180

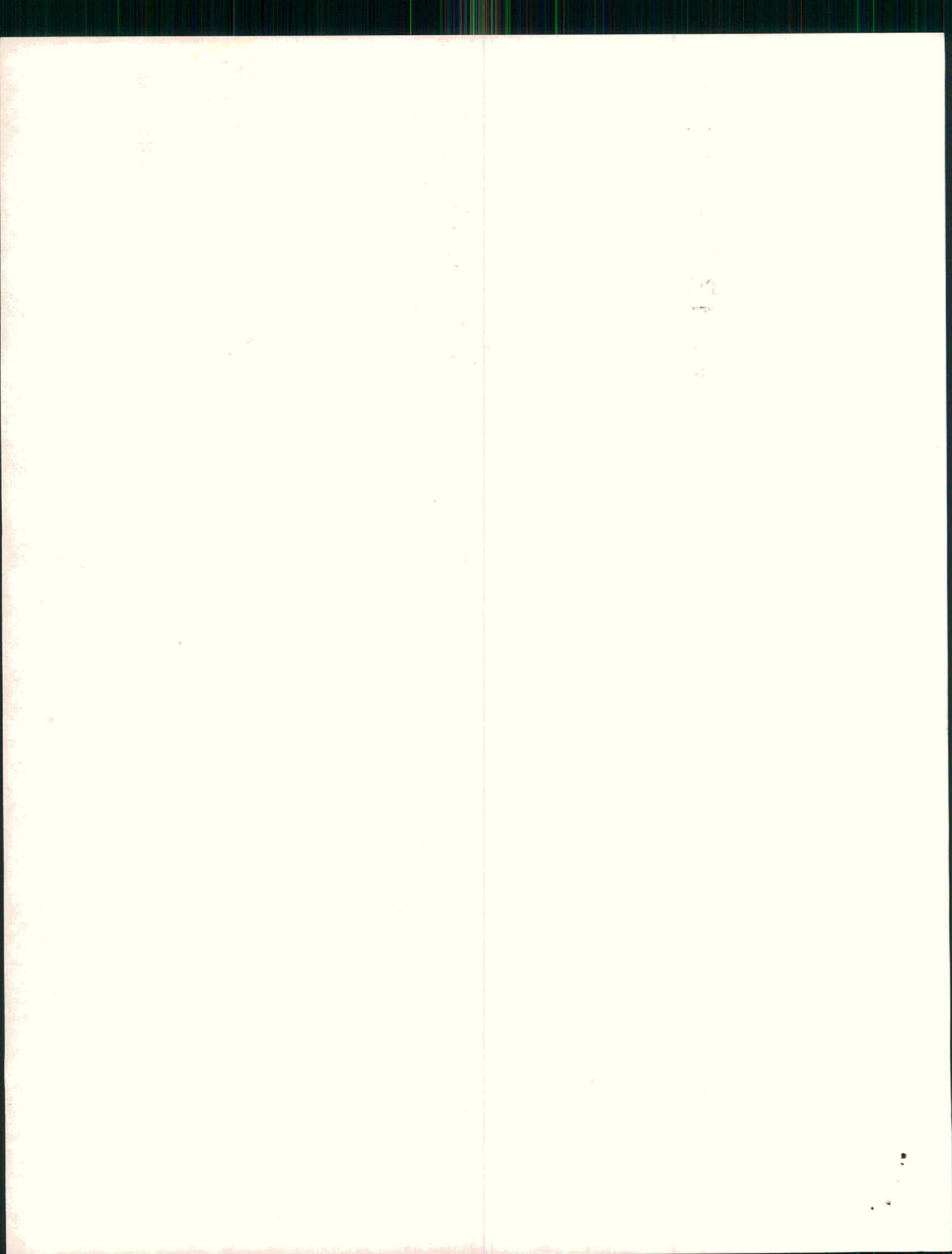
50

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Shop Packet Print

Page 3



Picklist Print

Page 4

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Work Order ID: 147531

147531

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

290

Each

1,895.000

2

MS21042L3

Nut

**

46
X m 135 135 PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

44

m133790

44

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

982

m134039

12

m134634

170

m134943

800

AN4-13A

Purchased

No

290

Each

732.0000

3

AN4-13A

Bolt

**

9
X m 135 390 PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

60

m134167

36

m134634

24

over003

500

m134852

400

m134943

100

ST344

152

m134754

152

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Picklist Print

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Page 5

Work Order ID: 147531

147531

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

290

Each

1,812.000

3

MS21042L4

Locknut

**

9
X M135297 PC
DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

181

m133769

181

OVER007

1000

m134861

1000

ST303

537

m134762

537

ST305

94

m130922

94

D2230-3

Manufactured

No

290

Each

185.0000

1

D2230-3

Mounting Lug

**

3
X B146 257 PC
DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

77

142522

1

143805

76

ST525A

100

144487

60

145363

40

D2732-030

Manufactured

No

290

Each

117.0000

2

D2732-030

Rubber Cushion - 3"

**

46
X B14044 PC
DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST410

117

144999

25

146999

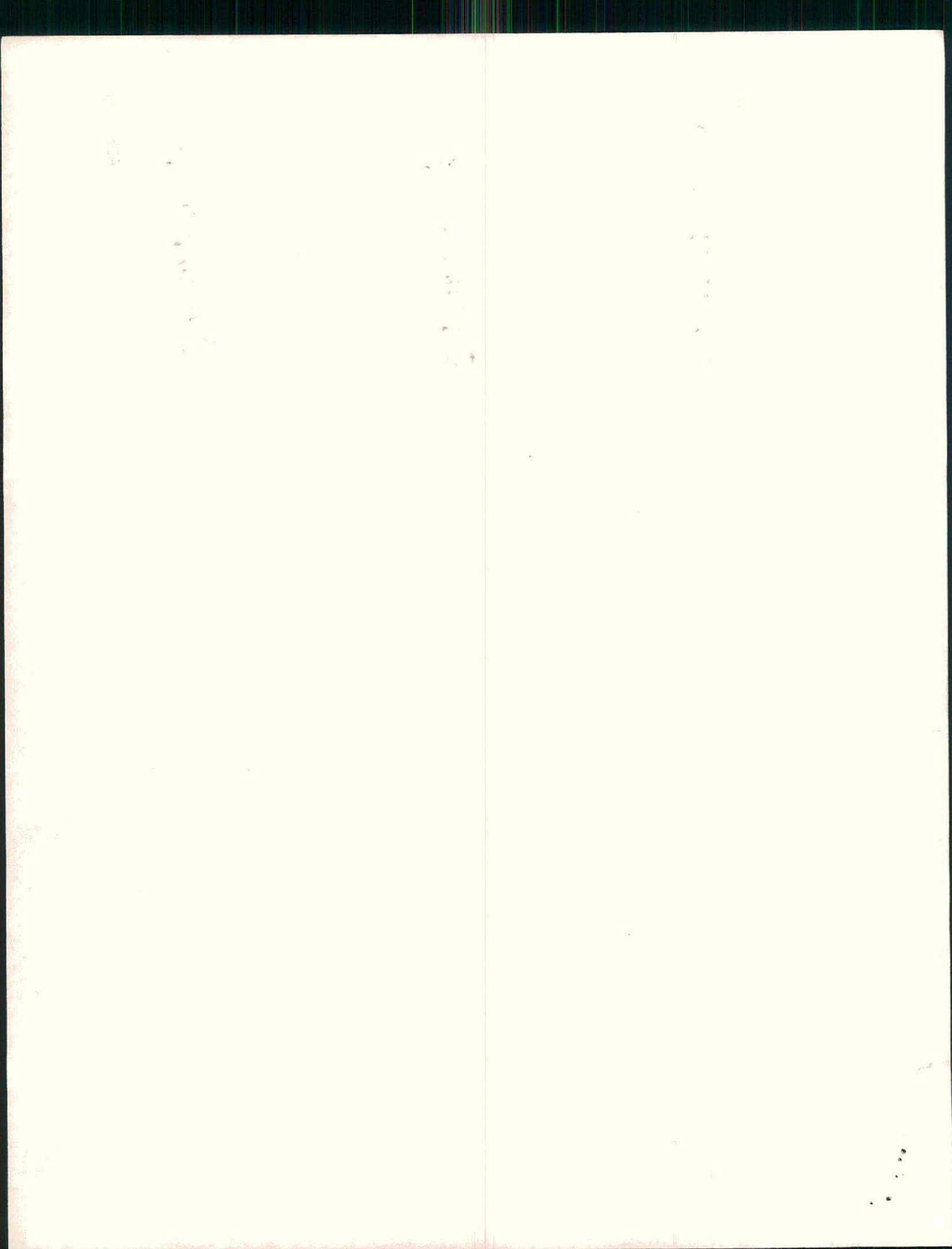
92

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Page 5



Picklist Print

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Page 6

Work Order ID: 147531

147531

Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016

Required Date: 6/8/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

290

Each

1,571.000

4

NAS1149D0363.J

Washer

**

12x m134955 PC

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

465

m134055

465

ST263

1106

m134606

106

m134676

1000

AUG 19 2016

DAS
27
9-89

1870

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2351	REV: E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

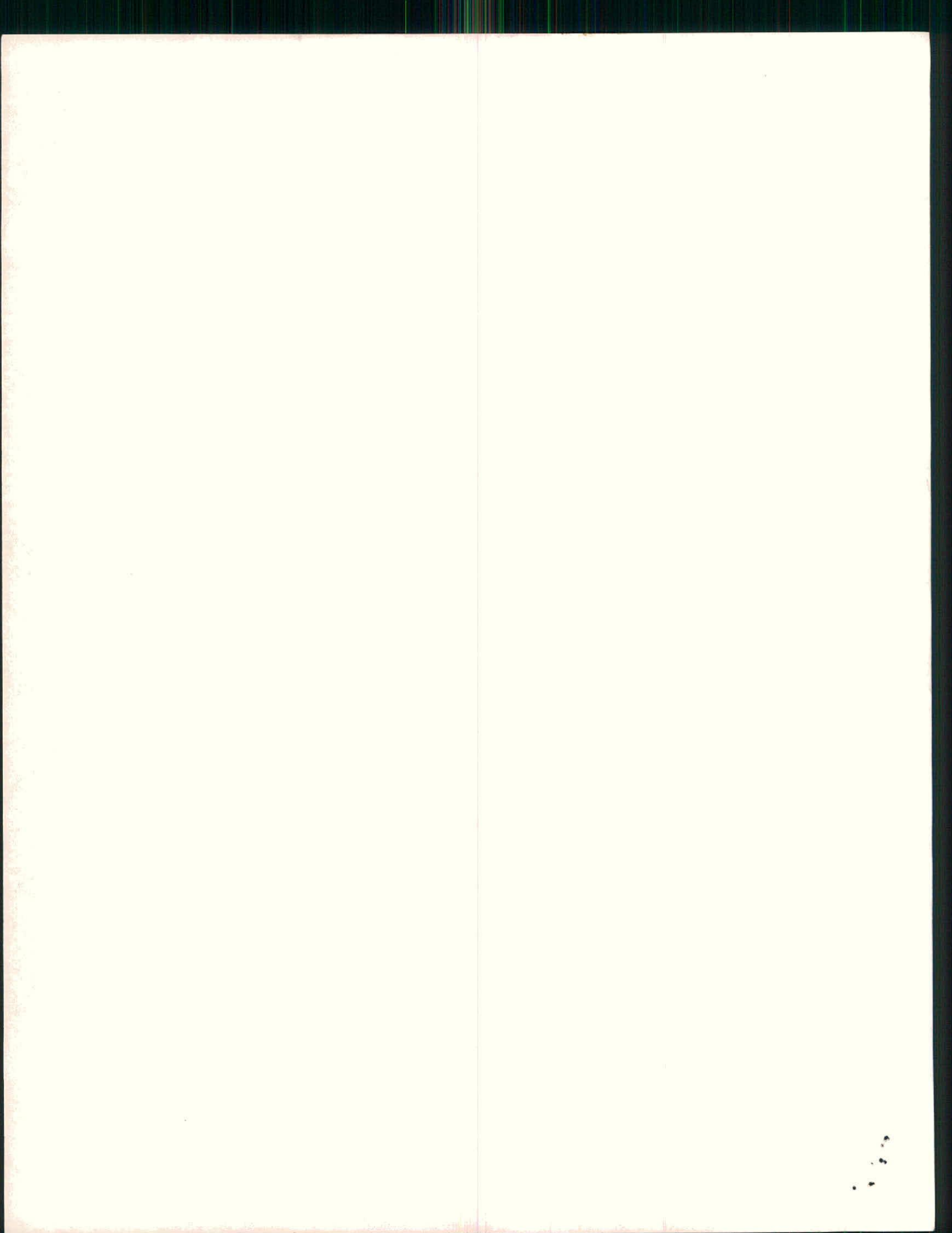
RELEASED
05.11.28 [Signature]**UNDER REVIEW**PH
ECN 1105

07.11.29 [Signature]

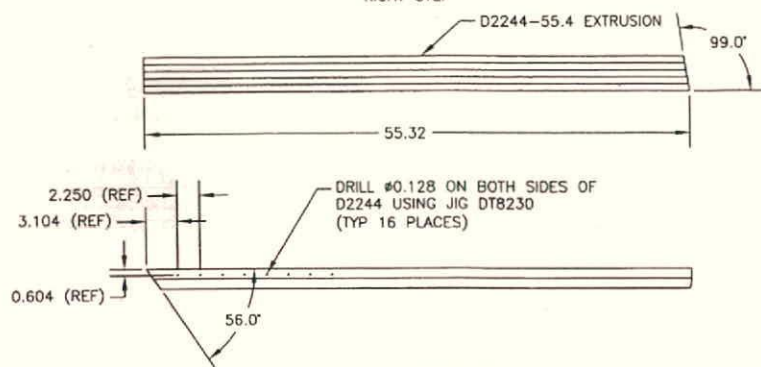
PER ECN 268

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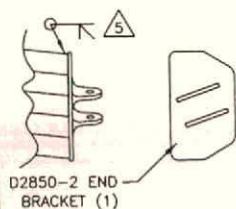
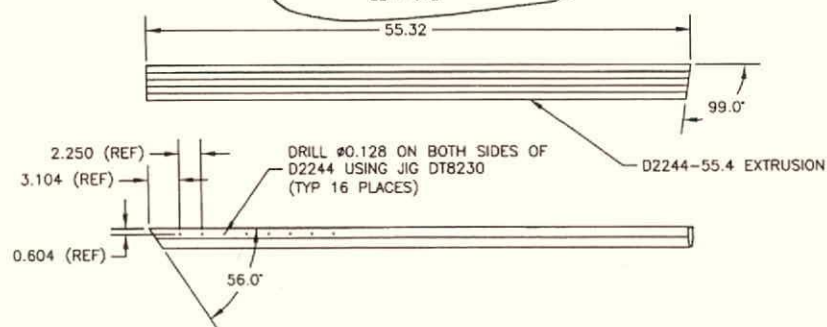
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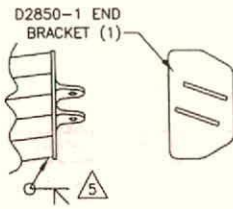
**D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP**



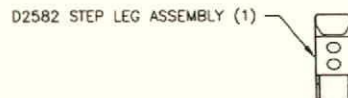
**D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP**



**DETAIL A
SCALE: 1:4**



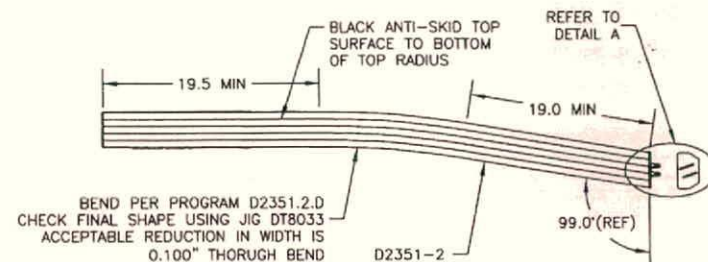
**DETAIL B
SCALE: 1:4**



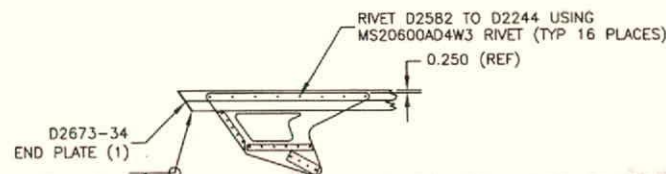
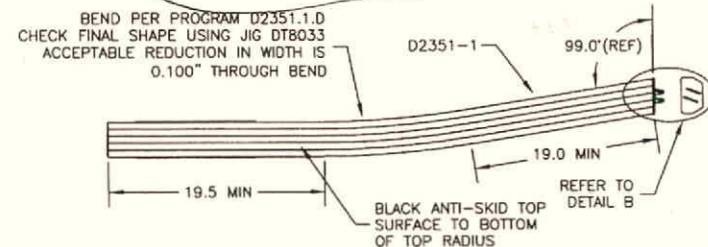
GENERAL NOTES

- 1) WELD PER DART QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- △ CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

**D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP**



**D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP**



RELEASED
05.11.28

UNDER REVIEW

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DESIGN KE	DRAWN BY PH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 2 OF 2
DATE 05.11.14	TITLE HIGH FLOAT STEP ASSEMBLY	SCALE 1:12	



Item ID: D350-591-121

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/27/2016 Start Qty: 2.00

2 4 SA 3
2 4 3

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 13 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2351-041

Rev E

IIN-D350-591

H

AUG 19 2016

DAS

9-89

DAS
21
9-89

AUG 19 2016

3

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

110

0.00

110

Large Fab

Large Fab

Memo

0.13

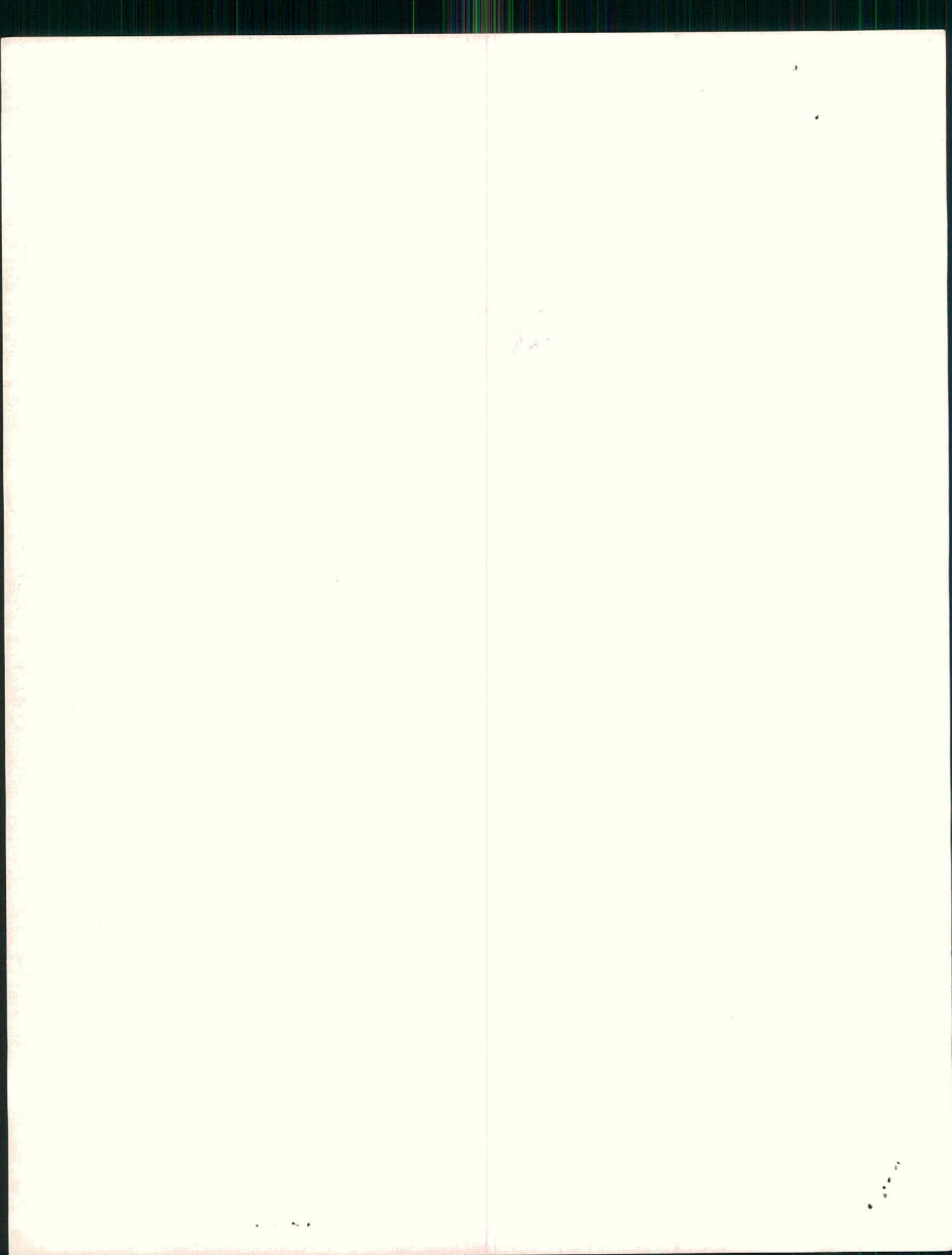
Large Fab

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

4 16-08-02



5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hel-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hel-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hel-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hel-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hel-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

